

Work Order ID 52443

September 23, 2009 3:21:32 PM

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Item ID: PB67-43001-37 *DG 09678*
 Revision ID: *BTC per CCN*
 Item Name: PB67-43001-37

Accept

Setup Start

Stop

Start Date: 09/28/2009 Start Qty: 2.00
 Required Date: 10/05/2009 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *09-09-23* Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	Rev B1								

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -125 and -343 as per dwg 2- install spring
 slotted pin as per dwg

09-09-24

2

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3 Sorlock

(2)

120

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *8:30 AM* OVEN TEMPERATURE:
 FINISH TIME: *3:20 PM*

09/10/09

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-37

Revision ID: B1

Item Name: PB67-43001-37

Start Date: 09/28/2009 Start Qty: 2.00

Required Date: 10/05/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

Bl 09-10-2
0.00

2

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Packaging

0.00

9/10/2 @SD

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

09/10/05

MF 09-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 52443

Parent Item: PB67-43001-37RevB1

Parent Item Name: PB67-43001-37

Start Date: 09/28/2009

Required Date: 10/05/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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240-107		Purchased	No			100	Each	296.0000	2.0000			
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SPRING SLOTTED PIN



Handwritten: 09.09.24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

296

109274

91

111088

205

PB67-43001-125RevB1 Manufactured No



Clevis

100	Each	5.0000	2.0000
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Handwritten: 09.09.24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

23993

5

PB67-43001-343RevB1 Manufactured No



Tube Arm

100	Each	13.0000	2.0000
-----	------	---------	--------



Handwritten: 09.09.24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

41213

6

41507

7

Handwritten: 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

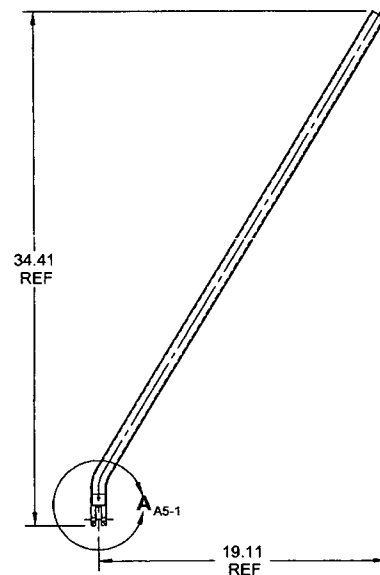
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

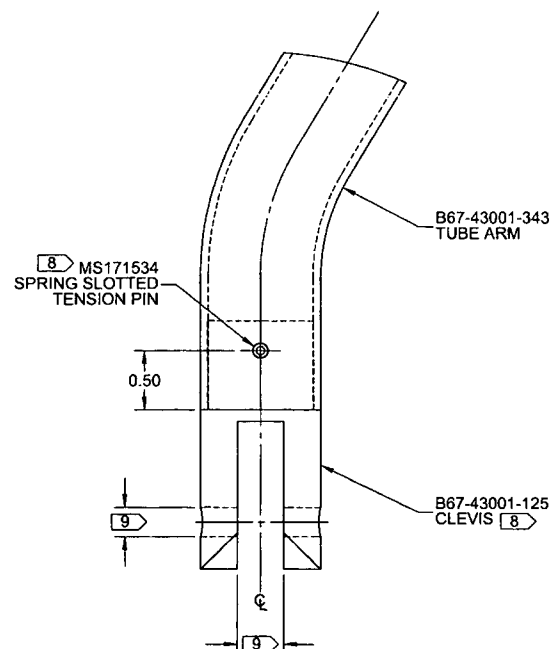
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ITEM	QTY -37	P/N	DESCRIPTION
1	X	B67-43001-37	TUBE ARM ASSEMBLY
3	1	B67-43001-343	TUBE ARM
4	1	B67-43001-125	CLEVIS
5	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)

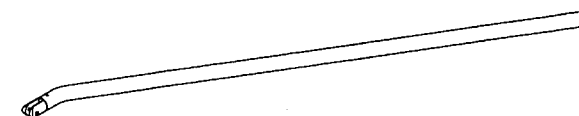


B67-43001-37 TUBE ARM ASSEMBLY



DETAIL A B7-1
SCALE 4 X

#52443



- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.81 lbs
 - 8) PRIOR TO POWDER COAT, ALIGN B67-43001-125 ON B67-43001-343 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-125 TO B67-43001-343 USING MS171534 SPRING SLOTTED TENSION PIN
 - 9) MASK PRIOR TO POWDER COAT

RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO.	REV. C
CHECKED	AD	B67-43001-37	SHEET 1 OF 1
MFG. APPR.	AD	TITLE	SCALE
APPROVED	N/A	TUBE ARM ASSEMBLY	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.24		

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